

# MISSISSIPPI DEPARTMENT OF TRANSPORTATION

**SPECIAL PROVISION NO. 907-402-6**

**CODE: (IS)**

**DATE: 05/01/2013**

**SUBJECT: Open Graded Friction Course (OGFC)**

Section 907-402, Open Graded Friction Course (OGFC), is hereby added to and made part of the 2004 Edition of the Mississippi Standard Specifications for Road and Bridge Construction as follows.

## **SECTION 907-402 -- OPEN GRADED FRICTION COURSE (OGFC)**

**907-402.01--Description.** These specifications include general requirements that are applicable to Open Graded Friction Course (OGFC).

This work consists of the construction of one lift of OGFC in accordance with these specifications and the specific requirements for the mixture to be produced and placed in reasonably close conformity with the lines, grades, thicknesses and typical sections shown on the plans or established by the Engineer.

### **907-402.01.1--Definitions.**

**Maximum Sieve Size** - Maximum sieve size is the smallest sieve size at which 100 percent of the aggregate passes.

**Nominal Maximum Sieve Size** - The nominal maximum sieve size is one sieve size larger than the first sieve to retain more than 10 percent of the aggregate.

**Mechanically Fractured Face** - An angular, rough, or broken surface of an aggregate particle created by crushing as determined by ASTM Designation: D 5821.

**Break Point Sieve** – The sieve size which separates the coarse and fine aggregate fractions of an OGFC mixture.

### **907-402.02--Materials.**

#### **907-402.02.1--Component Materials.**

**907-402.02.1.1--General.** Component materials will be conditionally accepted at the plant subject to later rejection if incorporated in a mixture or in work that fails to meet contract requirements.

**907-402.02.1.2--Aggregates.** The source of aggregates shall meet the applicable requirements of Section 703.

**907-402.02.1.2.1--Coarse Aggregate Blend.** Mechanically fractured faces by weight of the combined aggregate blend retained on the break point sieve shall be 90 percent two or more fractured faces, as determined by ASTM Designation: D 5821.

The maximum percentage by weight of flat and elongated particles, maximum to minimum dimension greater than three (3), shall not exceed 20% for OGFC mixtures. This shall be determined in accordance with ASTM Designation: D 4791, Section 8.4, on the combined mineral aggregate retained on the break point sieve.

The following table indicates the break point sieves for various nominal maximum size OGFC mixes.

<u>Mixture Size</u>	<u>Break Point Sieve</u>
12.5-mm	No. 4
9.5-mm	No. 8

**907-402.02.1.2.2--Combined Aggregate Blend.** All gradations will be based on percent passing by weight. The gradation requirements for OGFC mixtures are provided in the following table. Natural sand shall not be used in OGFC mixtures.

<b>Sieve Size</b>	<b>12.5-mm</b>	<b>9.5-mm</b>
12.5-mm	100	100
9.5-mm	80-89	90-100
4.75-mm	15-30	15-30
2.36-mm	10-20	10-20
75- $\mu$ m	2-5	2-5

**907-402.02.1.3--Bituminous Materials.** Bituminous materials shall meet the applicable requirements of Section 702 for the grade specified. A PG 76-22 asphalt binder shall be used for all OGFC mixtures. The asphalt content (by weight of total mix) shall be based on the bulk specific gravity of the combined aggregate blend ( $G_{sb}$ ) to ensure a constant asphalt binder volume in the mix for durability purposes. The relationship between  $G_{sb}$  and the minimum asphalt binder content by weight of total mix is provided in the following table.

<b>Combined Aggregate Bulk Specific Gravity, <math>G_{sb}</math></b>	<b>Minimum Asphalt Content (%)</b>
2.40	6.6
2.45	6.5
2.50	6.3
2.55	6.2
2.60	6.1
2.65	6.0
2.70	5.9
2.75	5.8
2.80	5.7
2.85	5.6

2.90	5.5
2.95	5.4
3.00	5.3

Tack coat shall meet the requirements of Subsection 907-402.03.1.2.

**907-402.02.1.4--Hydrated Lime.** Hydrated lime shall meet the requirements of Subsection 714.03.2 for lime used in soil stabilization.

**907-402.02.1.5--Asphalt Admixtures.** Additives for liquid asphalt, when required or permitted, shall meet the requirements of Subsection 702.08.

**907-402.02.1.6--Polymers.** Polymers for use in OGFC shall meet the requirements of Subsection 702.08.3.

**907-402.02.1.7--Stabilizing Fiber.** Stabilizing fiber shall meet the requirements of Subsection 907-714.07, with the exception that if mineral fibers are used, the minimum dosage rate shall be 0.40 percent.

**907-402.02.2--Blank.**

**907-402.02.3--Composition of Mixtures.**

**907-402.02.3.1--General.** Unless otherwise specified or permitted, the OGFC shall consist of a uniform mixture of asphalt, aggregate, stabilizing fibers, hydrated lime and, when required or necessary to obtain desired properties, antistripping agent and/or other materials.

The total amount of crushed limestone aggregate shall not exceed 50 percent of the total combined aggregate by weight.

Hydrated lime shall be used in all OGFC at the rate of one percent (1%) by weight of the total dry aggregate. The aggregate, prior to the addition of the hydrated lime, shall contain sufficient surface moisture. If necessary, the Contractor shall add moisture to the aggregate according to the procedures set out in Subsection 401.03.2.1.2.

The Contractor shall obtain a shipping ticket for each shipment of hydrated lime. The Contractor shall provide the District Materials Engineer with a copy of each shipping ticket from the supplier, including the date, time and weight of hydrated lime shipped.

Mixtures will require the addition of an antistripping agent when the Tensile Strength Ratio (MT-63\*) and/or the Boiling Water Test (MT-59) fail to meet the following criteria.

**Tensile Strength Ratio (TSR - MT-63\*)**

Wet Strength / Dry Strength	85 percent minimum
Interior Face Coating	95 percent minimum

Boiling Water Test (MT-59)

## Particle Coating

95 percent minimum

**\*Note:** MT-63 shall be performed at design air void content of OGFC mixtures rather than seven percent (7%) air voids. Vacuum saturation shall not be required. All other testing parameters shall apply.

Reclaimed asphalt pavement (RAP) or crushed reclaimed concrete may not be used as an aggregate component in the production of OGFC.

**907-402.02.3.1.1--Mixture Properties.** All mixes shall be designed according to Mississippi Test Method MT-83. OGFC mixes shall be designed with the Superpave gyratory compactor utilizing an  $N_{\text{design}}$  of 50 gyrations. The design air voids for all OGFC mixes shall be a minimum of 15.0 percent, as determined by ASTM Designation: D 6752 (vacuum sealing method). The ratio of the voids in the coarse aggregate in the compacted mix ( $VCA_{\text{mix}}$ ) to the voids in the coarse aggregate as determined with the dry rodded unit weight test ( $VCA_{\text{dr}}$ ) shall be less than 1.0.

The designed mixture shall have a draindown of less than 0.3 percent when tested in accordance with Mississippi Test Method MT-82. The minimum permeability of the mixture shall be 30 meters per day as determined by Mississippi Test Method MT-84. The aged abrasion loss of compacted specimens at the optimum asphalt content shall not exceed 40%, and the unaged abrasion loss of compacted specimens at the optimum asphalt content shall not exceed 30%, as determined by Mississippi Test Method MT-85.

**907-402.02.3.2--Job Mix Formula.** At least 14 working days prior to the proposed use of each mixture, the Contractor shall submit in writing to the Engineer a proposed job-mix formula or request the transfer of a verified job-mix formula as set forth in the latest edition of MDOT's Field Manual for HMA and MT-83. The job-mix formula shall be signed by a Certified Mixture Design Technician (CMDT).

The Department will perform the tests necessary for review of a proposed job-mix formula for each OGFC mixture free of charge one time only. A charge will be made for additional job-mix formulas submitted by the Contractor for review.

Review of the proposed job-mix formula will be based on ratio of Voids in the Coarse Aggregate ( $VCA_{\text{mix}}/VCA_{\text{dr}}$ ), draindown, permeability, abrasion loss, resistance to stripping, and other criteria specified for the mixture.

The mixture shall conform thereto within the range of tolerances specified for the particular mixture. No change in properties or proportion of any component of the job-mix formula shall be made without permission of the Engineer. The job-mix formula for each mixture shall be in effect until revised in writing by the Engineer.

A job-mix formula may be transferred to other contracts in accordance with conditions set forth in the Department's Field Manual for HMA.

The Contractor shall not place any OGFC prior to receiving “tentative” approval and a MDOT design number from the Central Laboratory.

When a change in source of materials, unsatisfactory mixture production results (such as segregation, bleeding, shoving, rutting over  $\frac{1}{8}$  inch, raveling & cracking) or changed conditions make it necessary, a new job-mix formula will be required. The conditions set out herein for the original job-mix formula are applicable to the new job-mix formula.

**907-402.02.4--Layer Thickness.** The minimum and maximum laying thickness for OGFC mixtures are provided in the following table.

Mixture Nominal Maximum Size	Single Lift Laying Thickness, Inches	
	Minimum	Maximum
12.5-mm	1	1 $\frac{1}{4}$
9.5-mm	$\frac{3}{4}$	1

**907-402.02.5--Contractor's Quality Management Program.**

**907-402.02.5.1--General.** The Contractor shall have full responsibility for quality management and maintain a quality control system that will furnish reasonable assurance that the mixtures and all component materials incorporated in the work conform to contract requirements. The Contractor shall have responsibility for the initial determination and all subsequent adjustments in proportioning materials used to produce the specified mixture. Adjustments to plant operation and spreading and compaction procedures shall be made immediately when results indicate that they are necessary. Mixture produced by the Contractor without the required testing or personnel on the project shall be subject to removal and replacement by the Contractor at no additional cost to the State.

**907-402.02.5.2--Personnel Requirements.** The Contractor shall provide at least one Certified Asphalt Technician-I (CAT-I) full-time during OGFC production at each plant site used to furnish material to the project. Sampling shall be conducted by a certified technician or by plant personnel under the direct observation of a certified technician. All testing, data analysis and data posting will be performed by the CAT-I or by an assistant under the direct supervision of the CAT-I. The Contractor shall have a Certified Asphalt Technician-II (CAT-II) available to make any necessary process adjustments. Technician certification shall be in accordance with MDOT's *Materials Division Inspection, Testing, and Certification Manual*, Section 1.3.3 - MDOT HMA Technician Certification Program. An organizational chart, including names, telephone numbers and current certification, of all those responsible for the quality control program shall be posted in the contractor's laboratory while the OGFC paving work is in progress.

**907-402.02.5.3--Testing Requirements.** As a minimum, the Contractor's quality management program shall include the following:

- (a) Bituminous Material. Provide the Engineer with samples in a sealed one quart metal container at the frequency given in MDOT SOP TMD-20-04-00-000.

- (b) Mechanically Fractured Face. Determine mechanically fractured face content of aggregates retained on the break point sieve, at a minimum of one test per day of production.
- (c) Mixture Gradation. Conduct extraction tests for gradation determination on the mixture. Sample according to the frequency in paragraph (h) and test according to Mississippi Test Method MT-31.
- (d) Total Voids. Determine total voids at  $N_{\text{Design}}$  from the results of bulk specific gravity tests on laboratory compacted specimens. Sample according to the sampling frequency in paragraph (h) and test according to ASTM Designation: D 6752.
- (e) Asphalt Content. Sample according to the sampling frequency in paragraph (h), and determine the asphalt content using one of the following procedures.

- (1) Nuclear gauge. (Mississippi Test Method MT-6)
- (2) Incinerator oven. (AASHTO Designation: T 308, Method A)

Draindown tests shall also be conducted according to Mississippi Test Method MT-82, at a minimum of one test per day of production..

- (f) Stripping Tests. Conduct a minimum of one stripping test at the beginning of each job-mix production and thereafter, at least once per each two weeks of production according to Mississippi Test Method: MT-63 (as amended) and one stripping test per day of production according to Mississippi Test Method: MT-59. Should either the TSR (MT-63) or the boiling water (MT-59) stripping tests fail, a new antistrip additive or rate shall be established or other changes made immediately that will result in a mixture which conforms to the specifications; otherwise, production shall be suspended until corrections are made.
- (g) Quality Control Charts. Plot the individual test data, the average of the last four tests and the control limits for the following items as a minimum:

Mixture Gradation (Percent Passing) Sieves:  
1/2-in, 3/8-in, No. 4, No. 8, and No. 200  
Asphalt Content, Percent  
Maximum Specific Gravity  
Total Voids @  $N_{\text{Design}}$ , Percent

Keep charts up-to-date and posted in a readily observable location. Charts may be kept on a computer; however, the charts shall be printed out a minimum of once each production day and displayed in the laboratory. Note any process changes or adjustments on the Air Voids chart.

- (h) Sampling Frequency. Conduct those tests as required above at the following frequency for each mixture produced based on the estimated plant tonnage at the beginning of the day.

<u>Total Estimated Production, tons</u>	<u>Number of Tests</u>
1-400	1
401-800	2
801-1200	3
1201+	4

- (i) **Sample Requirements.** Obtain the OGFC mixture samples from trucks at the plant. Obtain aggregate samples from cold feed bins or aggregate stockpile. Save a split portion of all mixture samples at the laboratory site in a dry and protected location for 14 calendar days. At the completion of the project, the remaining samples may be disposed of with the approval of the Engineer.

The above testing frequencies are for the estimated plant production for the day. If production is discontinued or interrupted, the tests will be conducted at the previously established sample tonnage points for the materials that are actually produced. If the production exceeds the estimated tonnage, sampling and testing will continue at the testing increments previously established for the day. A testing increment is defined as the estimated daily tonnage divided by the required number of tests from the table in Subsection 907-402.02.5.3 paragraph (h).

In addition to the above program, aggregate stockpile gradation tests (AASHTO Designations: T-11 and T-27) shall be conducted every other production day. Tests to determine  $VCA_{dr}$  shall be conducted on the first day of production and once for every eight production samples thereafter, with a minimum of one test per production week.

**907-402.02.5.4--Documentation.** The Contractor shall document all observations, records of inspection, adjustments to the mixture, and test results on a daily basis. All tests conducted by the Contractor in accordance with Subsection 907-402.02.5.3(g) shall be included in the running average calculations. If single tests are performed as a check on individual OGFC properties, between regular samples, without performing all tests required in Subsection 907-402.02.5.3(g), the results of those individual tests shall not be included in the running average calculations for that particular property. The Contractor shall record the results of observations and records of inspection as they occur in a permanent field record. The Contractor shall record all process adjustments and job mix formula (JMF) changes on the air void charts. The Contractor shall provide copies of all test data sheets and the daily summary reports on the appropriate Mississippi DOT forms to the Engineer on a daily basis. The Contractor shall provide a written description of any process change, including blend proportions, to the Engineer as they occur. Information provided to the Engineer must be received in the Engineer's office by no later than 9:00 AM the day after the OGFC is produced. Fourteen days after the completion of the placement of the OGFC, the Contractor shall provide the Engineer with the original testing records and control charts in a neat and orderly manner.

**907-402.02.5.5--Control Limits.** The following control limits for the job mix formula (JMF) and warning limits are based on a running average of the last four data points.

<u>Item</u>	<u>JMF Limits</u>	<u>Warning Limits</u>
Sieve - % Passing		
1/2-inch	± 4.0	± 3.0

3/8-inch	± 4.0	± 3.0
No. 4	± 3.0	± 2.0
No. 8	± 3.0	± 2.0
No. 200	± 1.5	± 1.0
Asphalt Content, %	-0.3 to +0.5	-0.2 to +0.4
Total Voids @ N <sub>Design</sub> , %	-1.3 to +2.5	-1.0 to +2.0

**907-402.02.5.6--Warning Bands.** Warning bands are defined as the area between the JMF limits and the warning limits.

**907-402.02.5.7--Job Mix Formula Adjustments.** A request for a JMF adjustment signed by a CAT-II may be made to the Engineer by the Contractor. Sufficient testing data shall be submitted with the request to justify the change. The requested change will be reviewed by the State Materials Engineer for the Department. If current production values meet the mixture design requirements, a revised JMF will be issued. Adjustments to the JMF shall conform to the latest edition of MDOT's Field Manual for HMA. Adjustments to the JMF to conform to actual production shall not exceed the tolerances specified for the JMF limits. Regardless of such tolerances, any adjusted JMF gradation shall be within the range given in Subsection 907-402.02.1.2.3 for the mixture specified. **The JMF asphalt content may only be adjusted after verification for minimum voids, permeability, and abrasion loss.**

**907-402.02.5.8--Actions and Adjustments.** Based on the process control test results for any property in question, the following actions shall be taken or adjustments made when appropriate:

- (a) When the running average trends toward the warning limits, the Contractor shall consider taking corrective action. The corrective action, if any, shall be documented. All tests shall be part of the contract files and shall be included in the running average calculations.
- (b) The Contractor shall notify the Engineer whenever the running average exceeds the warning limits.
- (c) If two consecutive running averages exceed the warning limit, the Contractor shall stop production and make adjustments. Production shall only be restarted after notifying the Engineer of the adjustments made.
- (d) If the adjustment made under (c) improves the process such that the running average after four additional tests is within the warning limits, the Contractor may continue production with no reduction in payment.
- (e) If the adjustment made under (c) does not improve the process and the running average after four additional tests stays in the warning band, the mixture will be considered unsatisfactory. Reduced payment for unsatisfactory mixtures will be applied starting from the stop point to the point when the running average is back within the warning limits in accordance with Subsection 907-402.02.6.3.
- (f) Failure to stop production and make adjustments when required shall subject all mixture produced from the stop point to the point when the running average is back within the warning limits to be considered unsatisfactory. Reduced payment for unsatisfactory mixtures will be applied in accordance with Subsection 907-402.02.6.3.
- (g) If the running average exceeds the JMF limits, the Contractor shall stop production and make adjustments. Production shall only be restarted after notifying the Engineer of the adjustments made.



- (h) All materials for which the running average exceeds the JMF limits will be considered unacceptable and shall be removed and replaced by the Contractor at no additional cost to the State. The Engineer will determine the quantity of material to be replaced based on a review of the individual testing data which make up the running average in question and an inspection of the completed pavement. If the Engineer decides to leave the mixture in place because of special circumstances, the quantity of mixture, as defined above, will be paid for in accordance with Subsection 907-402.02.6.3.
- (i) Single test results shall be compared to 1.7 times the warning and JMF limits. If the QC test results, as verified by the Engineer's tests (within allowable differences in Subsection 907-402.02.6.2), exceed these limits, the pay factor provided in Subsection 907-402.02.6.3 will apply for the quantity of material represented by the test(s). Single test limits will be used for the acceptance of projects when insufficient tonnage is produced to require four (4) Contractor's tests.
- (j) The above corrective action will also apply for a mixture when the Contractor's testing data has been proven incorrect. The Contractor's data will be considered incorrect when; 1) the Contractor's QC tests and the Engineer's verification tests do not agree within the allowable differences given in Subsection 907-402.02.6.2 and the difference can not be resolved, or 2) the Engineer's verification tests indicates that production is outside the JMF limits and the results have been substantiated by the Materials Division's test results. The Engineer's data will be used in place of the Contractor's data to determine the appropriate pay factor.

**907-402.02.5.9--Trial Section.** At the beginning of placement for the lift, the Contractor shall construct a trial section of a maximum of 500 linear feet of lane with the OGFC mix, for the purpose of establishing and evaluating consistent mixture and compaction properties. The Contractor shall use the trial section to adjust production process, if necessary, and to establish coordinated testing efforts between Contractor QC personnel and Department testing personnel. The Department shall determine the production point at which the mix shall be sampled and split with the Contractor during any trial section construction.

The Department will conduct verification tests for mixture quality within 24 hours of receipt of the sample. If the Department's tests on the mixture indicate both compliance with specified mix properties for a pay factor of 1.00 and verification of the Contractor's test results within the allowable differences specified in Subsection 907-402.02.6.2, no further trial sections are necessary. If a pay factor of less than 1.00 is determined for mix quality, a second trial section consisting of no more than 500 linear feet shall be constructed. If a pay factor of less than 1.00 is obtained in the second trial section, the Contractor will be required to repeat the above procedure at an offsite location until all pay factors are equal to 1.00. Full production may begin upon completion of a successful trial section. The Engineer reserves the right to have any trial section removed and replaced at no additional cost to the State, if the pay factor for any characteristic for a trial section is less than 0.75.

For actual payment purposes, a pay factor of 1.00 will be used for the first and second trial sections allowed to remain in place. Any required offsite trial sections will be constructed at no additional cost to the State.

**907-402.02.6--Standards of Acceptance.**

**907-402.02.6.1--General.** Acceptance for mixture quality (Total voids @  $N_{\text{Design}}$ , gradation, and asphalt content) will be based on random samples tested in accordance with the latest edition of MDOT's Field Manual for HMA.

**907-402.02.6.2--Assurance Program for Mixture Quality.**

The Engineer will conduct a quality assurance program. The quality assurance program will be accomplished as follows:

- 1) Conducting verification tests.
- 2) Validate Contractor test results.
- 3) Periodically observing Contractor quality control sampling and testing.
- 4) Monitoring required quality control charts and test results.
- 5) Sampling and testing materials at any time and at any point in the production or laydown process.

The rounding of all test results will be in accordance with Subsection 700.04.

The Engineer will conduct verification tests on samples taken by the Contractor under the direct supervision of the Engineer at a time specified by the Engineer. The frequency will be equal to or greater than ten percent (10%) of the tests required for Contractor quality control and the data will be provided to the Contractor within two asphalt mixture production days after the sample has been obtained by the Engineer. At least one sample shall be tested from the first two days of production. All testing and data analysis shall be performed by a Certified Asphalt Technician-I (CAT-I) or by an assistant under the direct supervision of the CAT-I. Certification shall be in accordance with the *MDOT HMA Technician Certification Program* chapter in the Materials Division Inspection, Testing, and Certification Manual. The Department shall post a chart giving the names and telephone numbers for the personnel responsible for the assurance program.

The Engineer shall be allowed to inspect Contractor testing equipment and equipment calibration records to confirm both calibration and condition. The Contractor shall calibrate and correlate all testing equipment in accordance with the latest versions of the Department's Test Methods and AASHTO Designation: R 18.

Random differences between the Engineer's verification tests and the current running average of four quality control tests at the time of obtaining the verification sample will be considered acceptable if within the following limits.

Item	Allowable Differences
Sieve - % Passing	
3/8-inch and above	6.0
No. 4	5.0
No. 8	4.0
No. 200	2.0
AC Content	0.4
Specimen Bulk SG, Gmb @ $N_{\text{Design}}$	0.030
Maximum SG, Gmm	0.020

If four quality control tests have not been tested prior to the time of the first verification test, the verification test results will be compared to the average of the preceding quality control tests. If the verification test is the first material tested on the project or if a significant process adjustment was made just prior to the verification test, the verification test results will be compared to the average of four subsequent quality control test results. For all other cases after a significant process adjustment, the verification test results will be compared to the average of the preceding quality control tests, taken after the adjustment, as in the case of a new project start-up when four quality control tests are not available.

In the event that; 1) the comparison of the Contractor's running average quality control data and Engineer's quality assurance verification test results are outside the allowable differences in the above table, or 2) if a bias exists between the results, such that one of the results is predominately higher or lower than the other, and the Engineer's results fail to meet the JMF control limits, the Engineer will investigate the reason immediately. As soon as the need for an investigation becomes known, the Engineer will increase the quality assurance sampling rate to the same frequency required for Contractor testing. The additional samples obtained by the Engineer may be used as part of the investigation process or for routine quality assurance verification tests. The Engineer's investigation may include testing of the remaining quality control split samples, review and observation of the Contractor's testing procedures and equipment, and a comparison of split sample test results by the Contractor quality control laboratory, Department quality assurance laboratory and the Materials Division laboratory. The procedures outlined in the latest edition of MDOT's Field Manual for HMA may be used as a guide for the investigation. In the event that the Contractor's results are determined to be incorrect, the Engineer's results will be used for the quality control data and the appropriate payment for the mixture will be based on the procedures specified in Subsection 907- 402.02.5.8(j).

The Engineer will periodically witness the sampling and testing being performed by the Contractor. The Engineer, both verbally and in writing, will promptly notify the Contractor of any observed deficiencies. When differences exist between the Contractor and the Engineer which cannot be resolved, a decision will be made by the State Materials Engineer, acting as the referee. The Contractor will be promptly notified in writing of the decision. If the deficiencies are not corrected, the Engineer will stop production until corrective action is taken.

**907-402.02.6.3--Acceptance Procedure for Mixture Quality.** All obviously defective material or mixture will be subject to rejection by the Engineer. Such defective material or mixture shall not be incorporated into the finished work. If the defective material has already been placed in the work, the material shall be removed and replaced at no additional cost to the State.

The Engineer will base final acceptance of the asphalt mixture production on the results of the Contractor's testing for total voids, gradation, and asphalt content as verified by the Engineer in the manner hereinbefore described and the uniformity and condition of the completed pavement. Areas of pavement that exhibit nonuniformity or failures (materials or construction related) such as but not limited to segregation, bleeding, shoving, rutting over 1/8 inch, raveling, slippage, or cracking will not be accepted. Such areas will be removed and replaced at no additional cost to the State.

Bituminous mixture placed prior to correction for deficiencies in total voids @  $N_{Design}$ , gradation, or asphalt content, as required in Subsection 907-402.02.5.8 and determined by the Engineer

satisfactory to remain in place will be paid for in accordance with the following pay factors times the contract unit price per ton.

**Pay Factor for Mixture Quality \***

Item	Produced in Warning Bands	Produced Outside JMF Limits (Allowed to Remain in Place)
Gradation	0.90	0.50
Asphalt Content	0.85	0.50
Total Voids @ N <sub>Design</sub>	0.70	0.50

\* The minimum single payment will apply.

**907-402.02.7--Acceptance Procedure for OGFC Pavement Smoothness.** The OGFC will not be considered a surface lift in the completed pavement structure. There shall be no smoothness, bump and/or dip requirements for OGFC pavements.

**907-402.03--Construction Requirements.** Mississippi DOT has adopted the “Hot-Mix Asphalt Paving Handbook” as the guideline for acceptable asphalt construction practices.

**907-402.03.1--Specific Requirements.**

**907-402.03.1.1--Weather Limitations.** The mixture shall not be placed when weather conditions prevent the proper handling and finishing or the surface on which it is to be placed is wet or frozen. At the time of placement, the air and pavement surface temperature limitations shall be equal to or exceed 55°F.

When paving operations are discontinued because of rain, the mixture in transit shall be protected until the rain ceases. The surface on which the mixture is to be placed shall be swept to remove as much moisture as possible and the mixture may then be placed subject to removal and replacement at no additional cost to the State if contract requirements are not met.

**907-402.03.1.2--Tack Coat.** Tack coat for OGFC shall be hot applied, asphalt cement of performance grade PG 76-22 or one from the Department’s Approved Sources of Materials under the category “Open Graded Friction Course (OGFC) Asphalt Tack Materials”. PG 76-22 binder shall meet the requirements of Section 702 of the Standard Specifications.

Tack Coat for OGFC shall be applied with a distributor spray bar at the applied rate of between 0.10 and 0.14 gallons per square yard. The application rate of the tack coat shall result in complete and uniform coverage of the underlying lift in which the OGFC will be placed.

The tack coat for OGFC should be allowed to break, cool and/or cure until a point in time that the tack coat does not pick-up or track due to traffic from trucks or the paving equipment. It should be pointed out that breaking, cooling, and/or curing times of the tack coat may vary based on the environmental conditions at the time of placement.

**907-402.03.1.3--Blank.**

**907-402.03.2--Bituminous Mixing Plants.****907-402.03.2.1--Plant Requirements.**

**907-402.03.2.1.1--Cold Aggregate Storage.** The cold storage for hydrated lime shall be a separate bulk storage bin with a vane feeder or other approved feeder system which can readily be calibrated. The system shall provide a means for easy sampling of the hydrated lime additive and verifying the quantity of lime dispensed. The feeder system shall require a totalizer.

The hydrated lime additive equipment shall be interlocked and synchronized with the cold feed controls to operate concurrently with the cold feed operation which will automatically adjust the hydrated lime feed to variations in the cold aggregate feed. A positive signal system shall be installed which will automatically shut the plant down when malfunctions cause an improper supply of hydrated lime or water.

The plant shall not operate unless the entire hydrated lime system is functioning properly.

**907-402.03.2.1.2--Cold Aggregate Feed.** The hydrated lime shall be dispensed dry or as a slurry (1 part hydrated lime to 3 parts water) directly onto the composite aggregate between the cold feed and the dryer.

When hydrated lime is introduced dry, a spray bar or other approved system capable of spraying all aggregate with water shall be installed in order to maintain all aggregate at the moisture condition set out in Subsection 907-402.02.3.1 prior to addition of the hydrated lime. An alternate system for spraying the coarse aggregate stockpiles may be allowed when approved by the Engineer. The approved equipment and methods shall consistently maintain the aggregate in a uniform, surface wet condition. The moisture content of the aggregate-hydrated lime mixture, following spraying and mixing, shall be introduced into the automatic moisture controls of the plant.

The aggregate-hydrated lime mixture shall be uniformly blended by some mechanical means such as a motorized "on the belt" mixer or pug mill located between the cold feed and the dryer. Other mixing devices may be used subject to approval by the Engineer.

A maximum of forty five (45) percent of the total aggregate blend may be fed through any single cold feed bin. If the JMF calls for more than forty five (45) percent of a specific aggregate, that aggregate must be fed through two (2) or more separate cold feed bins.

**907-402.03.2.1.3--Dryer.** The efficiency of drying aggregates shall be such that the moisture content of an OGFC mixture shall not exceed 0.50 percent by weight of the total mixture, and the moisture content of any underlying lifts shall not exceed 0.75 percent by weight of the total mixture being produced.

**907-402.03.2.1.4--Stabilizing Fiber Addition.** For batch plants, fibers shall be added (manually or automatic) to either the pugmill or the weigh hopper. At least one aggregate source shall be added prior to the fiber addition, if fibers are added to the weigh hopper. Otherwise, fibers shall

be added to the pugmill immediately after the addition of all the aggregate and prior to the addition of the asphalt binder.

**907-402.03.2.1.4.1--Manual Method.** Provided it is demonstrated to the satisfaction of the Engineer that the proper dosage rate of the stabilizing fibers is uniformly distributed into the mix, manual introduction of the fibers is acceptable when a batch plant is used to make the mix. When the fibers are available in prepackaged (weighed) containers, proper dosage may be pre-determined per batch. A device is required to interrupt mixture production and warn the plant operator if the operator manually feeding the fiber fails to introduce it properly.

Manual introduction of fibers shall not be used in drum plants.

**907-402.03.2.1.4.2--Automatic Method.** The automatic method requires specialized equipment that can accurately proportion and meter, by weight, the proper amount per batch for batch plants, or continuously and in a steady uniform manner for drum plants. Fiber, pelletized or loose, shall not be fed through the cold feed bins or through the RAP bins.

These proportioning devices shall be interlocked with the plant system and controlled to  $\pm 10$  percent of the weight of the fibers required so as to maintain the correct proportions for all production rates and batch sizes. During trial section construction, an equipment calibration check shall be performed to the satisfaction of the Engineer that shows the fiber is being accurately metered and uniformly distributed into the mix. These metering devices shall provide in- process high flow ( $\geq 10$  percent or more) and low flow ( $< 10$  percent or less) plant operator notification and interrupt the mix production where the fiber rate is not properly controlled. The fiber metering system shall also provide a record of feed rate (weight per time) and include a minimum two-foot long section of translucent pipe for visual confirmation of consistent flow rates. Care shall be taken to insure that the fibers are not entrained in the plant's exhaust system. If there is any evidence of fiber in the bag-house or wet-washer fines, the liquid asphalt binder line and/or the fiber line shall be relocated so that the fiber is captured by liquid asphalt binder spray and incorporated into the mix. If there is any evidence of clumps of fibers or pellets at the discharge chute, the contractor shall increase the mixing time and/or intensity. This may entail extending the liquid asphalt binder and fiber feeding lines further into the drum.

**Note:** Various stabilizing fiber suppliers have developed methodology and equipment for metering bulk loose and pelletized fiber into asphalt plants. Whenever the fiber supplier's recommendations are more stringent than this specification, the fiber supplier's recommendations shall control.

**907-402.03.2.1.5--Control of Bituminous Material and Antistripping Agent.** Specified bituminous materials from different manufacturers or from different refineries of a single manufacturer shall not be mixed in the plant's asphalt cement supply system storage tank and used in the work without prior written approval of the Engineer. Approval is contingent upon the Engineer's receipt of three copies of the manufacturer's certified test report(s) from the Contractor showing that the bituminous material blend conforms to the specifications.

A satisfactory method of weighing or metering shall be provided to ensure the specified quantity of bituminous material. Provisions shall be provided for checking the quantity or rate of flow. Weighing or metering devices shall be accurate within plus or minus one-half percent.

The antistripping agent shall be injected into the bituminous material immediately prior to the mixing operation with an approved in-line injector system capable of being calibrated so as to ensure the prescribed dosage.

An in-line spigot for sampling of asphalt shall be located between the asphalt storage tank and the antistripping agent in-line injector.

**907-402.03.2.1.6--Thermometric Equipment.** An armored thermometer of adequate range and calibrated in 5°F increments shall be fixed at a suitable location in the bituminous line near the charging valve of the mixer unit.

The plant shall be equipped with an approved dial-scale, mercury-actuated thermometer, pyrometer or other approved thermometric instrument placed at the discharge chute of the dryer to measure the temperature of the material.

When the temperature control is unsatisfactory, the Engineer may require an approved temperature-recording apparatus for better regulation of the temperature.

**907-402.03.2.1.7--Screens.** A 1-inch scalping screen shall be used.

**907-402.03.2.1.8--Dust Collector.** The plant shall be equipped with a dust collector constructed to waste or return collected material. When collected material is returned, it shall be returned through a controlling device which will provide a uniform flow of material into the aggregate mixture.

**907-402.03.2.1.9--Safety Requirements.** A platform or other suitable device shall be provided so the Engineer will have access to the truck bodies for sampling and mixture temperature data.

**907-402.03.2.1.10--Blank.**

**907-402.03.2.1.11--Truck Scales.** The specifications, tolerances and regulations for commercial weighing and measuring devices as recommended by the National Bureau of Standards [National Institute of Standards and Technology (NIST) Handbook 44] shall govern truck scales used in the State of Mississippi, except weighing devices with a capacity of ten thousand (10,000) pounds or more used to weigh road construction materials (i.e. sand, gravel, asphalt, fill dirt, topsoil and concrete) shall have a tolerance of one-half of one percent (1/2 of 1%) in lieu of the requirements of Handbook 44 and shall be regulated by the Mississippi Department of Transportation.

Scales shall be checked and certified by a scale company certified in heavy truck weights by the Mississippi Department of Agriculture and Commerce. In the case of scales used for measurement of materials on Department of Transportation projects, certification shall be performed in the presence of an authorized representative of the Department or a copy of the certification may be furnished for scales that have been checked and certified within the last six

months for use on other Department of Transportation projects and are still in the position where previously tested. Scales that have not been checked and certified under NIST Handbook 44 guidelines, except for the herein modified tolerances allowed, shall be so checked and certified prior to use for measurement of materials on Department of Transportation projects. Tests shall be continued on six month intervals with the test conducted in the presence of an authorized representative of the Department.

Truck scales shall be accurate to one-half of one percent of the applied load, shall be sensitive to 20 pounds, and shall have a graduation of not more than 20 pounds.

The Contractor may use an electronic weighing system approved by the Engineer in lieu of truck scales. The system shall be equipped with an automatic print out system which will print a ticket for each load with the following information:

MDOT, Contractor's name, project number, county, ticket number, load number, pay item number, item description of the material delivered, date, time of day, haul vehicle number, gross weight, tare weight, net weight and total daily net weight.

When approved by the Engineer and materials are measured directly from a storage bin equipped with load cells, exceptions may be made to the gross and tare weight requirements.

The ticket shall also have a place for recording the temperature of OGFC mixtures, if applicable, and the signatures of MDOT's plant and roadway inspectors. The load numbers for each project shall begin with load number one (1) for the first load of the day and shall be numbered consecutively without a break until the last load of the day. The Contractor shall provide MDOT with an original and one copy of each ticket. When the ticket information provided by the Contractor proves to be unsatisfactory, MDOT will use imprinter(s) and imprinter tickets to record load information. All recorded weights shall be in pounds and shall be accurate to within one-half of one percent of the true weight, and the system shall be sensitive to 20 pounds. The Engineer will require random loads to be checked on certified platform scales at no cost to the Department.

When an electronic weighing system utilizes the plant scales of a batch plant, the system may be used only in conjunction with a fully automatic batching and control system.

**907-402.03.2.2--Additional Requirements for Batching Plants.**

**907-402.03.2.2.1--Plant Scales.** The plant batch scale weight shall not exceed the platform scale weight by more than one percent (1%).

**907-402.03.2.3--Additional Requirements for Drum Mixing Plants.**

**907-402.03.2.3.1--Plant Controls.** The plant shall be operated with all the automatic controls as designed and provided by the plant manufacturer. If the automatic controls malfunction, brief periods of manual operations to complete the day's work or to protect the work already placed may be conducted with the approval of the Engineer. During manual operation, the Contractor must continue to produce a uniform mixture meeting all contract requirements.



**907-402.03.2.3.2--Aggregate Handling and Proportioning.** A screening unit shall be placed between the bins and the mixer to remove oversized aggregate, roots, clayballs, etc.

**907-402.03.2.4--Surge or Storage Bins.** Normally the surge bins shall be emptied at the end of each day's operation. During breakdowns or adverse weather conditions, the material may be stored for a period not to exceed three hours in a well-sealed, well-insulated, heated bin.

**907-402.03.3--Hauling Equipment.** The inside surfaces of each vehicle bed shall be coated with a light application of water and thin oil, soap solution, lime water solution or other approved material to prevent the mixture from sticking. Diesel fuel or gasoline shall not be used to lubricate vehicle beds. Truck beds shall be raised to drain excessive lubricants before placing mixture in the bed. An excess of lubricant will not be permitted.

**907-402.03.4--Bituminous Pavers.** The screed or strikeoff assembly shall be capable of vibrating and heating the full width of the mixture being placed and shall lay the lift with an automatic control device to the specified slope and grade without tearing, pulling or gouging the mixture surface.

**907-402.03.5--Rollers.** All rollers shall be self-propelled units capable of maintaining a smooth and uniform forward and reverse speed as required for proper compaction. Pneumatic-tired rollers shall not be permitted for compacting OGFC mixes. Rollers shall be equipped with adjustable scrapers, water tanks, mats and a device for wetting the wheels to prevent the mixture from sticking. Adhesion of the mixture to the rollers will not be permitted. The use of diesel fuel or gasoline for cleaning roller wheels, or to aid in preventing the mixture from sticking to the wheels, is prohibited.

All rollers shall be in good mechanical condition, free from leaking fuels and lubricants, loose link motion, faulty steering mechanism, worn king bolts and bearings. They shall be operational at slow speeds to avoid displacement of the mixture and capable of reversing direction smoothly and without backlash.

**907-402.03.6--Preparation of Grade.** The foundation upon which OGFC pavement is to be placed shall be prepared in accordance with the applicable Section of the Standard Specifications.

Unless otherwise directed, tack coat shall be applied to the underlying surface on which the mixture is to be placed. Emulsions, if used, must be allowed to "break" prior to placement of the bituminous mixture.

Bituminous mixture shall not be placed against the edge of pavements, curbs, gutters, manholes and other structures until sprayed with a thin uniform tack coating. The tack coat shall be protected until the mixture has been placed.

Existing pavements that require preliminary leveling or patching in advance of placing the OGFC mixture shall be sprayed with a tack coat material and then brought as nearly as practicable to uniform grade and cross section. The material shall be placed by hand or machine in one or more compacted layers approximately two (2) inches or less in compacted thickness.

**907-402.03.7--Blank.**

**907-402.03.8--Preparation of Mixture.** The temperature of the mixture, when discharged from the mixer, shall not exceed 340°F.

**907-402.03.9--Material Transfer Equipment.** Except for the areas mentioned below, the material transferred from the hauling unit shall be remixed prior to being placed in the paver hopper or insert by using an approved Materials Transfer Device. Information on approved devices can be obtained from the State Construction Engineer. Areas excluded from this requirement include: temporary work of short duration, detours, bridge replacement projects having less than 1,000 feet of pavement on each side of the structure, acceleration and deceleration lanes less than 1,000 feet in length, tapered sections, transition sections (for width), shoulders less than 10 feet in width, crossovers, ramps, side street returns and other areas designated by the Engineer.

**907-402.03.10--Spreading and Finishing.** The mixture shall be spread to the depth and width that will provide the specified compacted thickness, line, grade and cross section. Placing of the mixture shall be as continuous as possible. On areas where mechanical spreading and finishing is impracticable, the mixture may be spread, raked and luted by hand tools.

Immediately after screeding and prior to compaction, the surface shall be checked by the Contractor and irregularities adjusted. When the edge is feathered as in a wedge lift, it may be sealed by rolling. Irregularities in alignment and grade along the edges shall be corrected before the edges are rolled.

Hauling, spreading and finishing equipment shall be furnished that is capable of and operated in such a manner that the rolling operation will satisfactorily correct any surface blemishes.

The longitudinal joint in the subsequent lift shall offset that in the underlying lift by approximately six (6) inches. However, the joint in the top lift shall be at the centerline or lane line.

**907-402.03.11--Roadway Compaction.** Compaction shall be achieved by two to three passes of a 10 to 12-ton steel wheel roller operating in static mode. Finish rolling to remove any roller marks shall be performed after the mat temperature decreases to 250°F.

**907-402.03.12--Joints.** Joints between previously placed pavement and pavement being placed shall be so formed as to insure thorough and continuous bond.

The contact surface of longitudinal joints, except hot joints, shall be sprayed with a thin uniform tack coating before additional mixture is placed against the previously placed material.

**907-402.04--Method of Measurement.** Open Graded Friction Course will be measured by the ton. The weight of the composite mixture shall be determined in accordance with the provisions of Subsection 907-402.03.2.1.11.

Bituminous Tack Coat for Open Graded Friction Course shall be measured by the gallon as in accordance with the provisions of Subsections 109.01 and 410.04.

**907-402-05--Basis of Payment.** Subject to the adjustments set forth in Subsection 907-402.02.6.3, Open Graded Friction Course, measured as prescribed above, will be paid for at the contract unit price per ton and shall be full compensation for completing the work.

Bituminous Tack Coat, measured as prescribed above, will be paid for at the contract unit price per gallon, which price shall be full compensation for completing the work.

Payment will be made under the following items:

907-402-A: Open Graded Friction Course,  $\frac{*}{\text{Mixture}}$  - per ton

907-402-B: Bituminous Tack Coat - per gallon

\* 9.5-mm mixture or 12.5-mm mixture